



(19) Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number: **0 472 431 A2**

(12)

EUROPEAN PATENT APPLICATION

(21) Application number: **91307743.4**

(51) Int. Cl.⁵: **B29C 47/40**

(22) Date of filing: **22.08.91**

(30) Priority: **22.08.90 JP 222260/90**
22.08.90 JP 222261/90

(43) Date of publication of application:
26.02.92 Bulletin 92/09

(84) Designated Contracting States:
DE FR GB SE

(71) Applicant: **Moriyama, Masao**
13-508, Tendocho 17
Nishinomiya, Hyogo 663 (JP)

(72) Inventor: **Moriyama, Masao**
13-508, Tendocho 17
Nishinomiya, Hyogo 663 (JP)

(74) Representative: **Marlow, Nicholas Simon**
Reddie & Grose 16, Theobalds Road
London WC1X 8PL (GB)

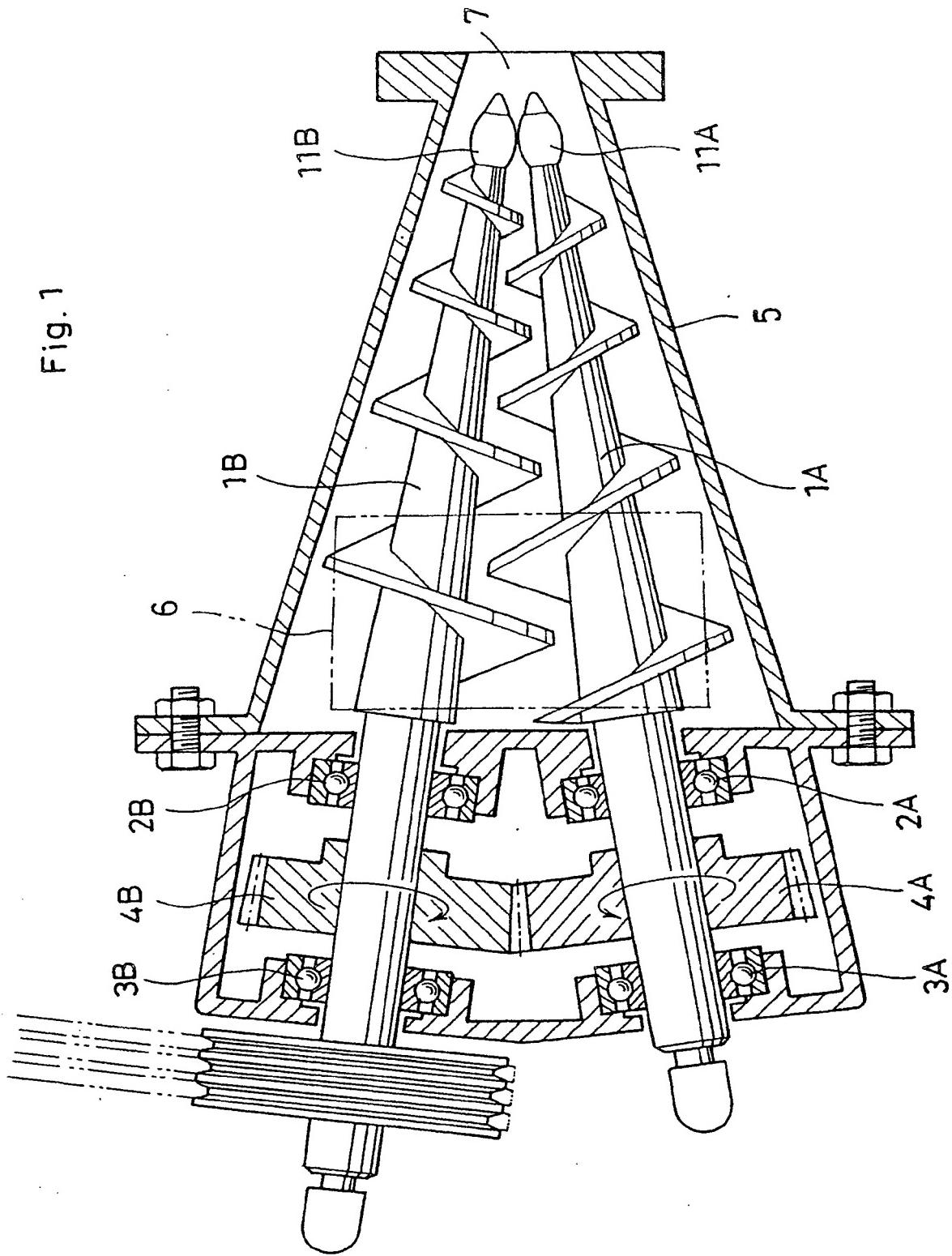
(54) **Twin conical screw extruder.**

(57) A twin conical screw extruder comprises two conically threaded rotors 1A,1B in a conical housing 5. The axes of the rotors converge toward their tips, adjacent the outlet 7 of the housing. The tips are each provided with a resilient pressurizing member 11A,11B. These bear on each other to urge the rotors apart, thereby enabling them to resist the force directing them further apart exerted by material being extruded.

EP 0 472 431 A2

Jouve, 18, rue Saint-Denis, 75001 PARIS

Fig. 1



Background of the Invention

The present invention relates to a twin conical screw extruder for extruding a highly viscous material such as plastics, rubber or the like.

In the twin conical screw extruder, the container is generally reduced in section area in the direction toward the tips of the rotors. Accordingly, the internal pressure is increased in inverse proportion to such reduction. This is advantageous in that a strong extruding force is obtained for the rotor lengths.

The inventor of the present invention had proposed an extruder utilizing the advantage above-mentioned, which was allowed as U.S.P. No. 4,764,020.

In a conventional twin conical screw extruder including the prior art above-mentioned, the axes of bearings which support the base portions of two rotors, are naturally identical with the axes of the twin conical container which houses the rotors. Accordingly, the angle α formed by the axes of the bearings is equal to the angle α formed by the axes of the twin conical container. At a non-load state where the container is not filled with a material to be extruded, the rotor shafts are straight and do not interfere with each other even though the screw mountain portions are meshed with each other, so that gaps are formed between the rotors.

In the prior art, when the rotors are rotated with the screws meshed with each other, the internal pressure applied to the material becomes the highest in the vicinity of the points at which the screws are meshed with each other, i.e., the plane between and including the axes of the rotors. Further, the internal pressure is increased in the direction toward the tips of the rotors. Accordingly, the tips of the twin rotors are pushingly turned outwardly. Thus, at the time when a load is applied, the rotor shafts are so resiliently deformed as to be outwardly turned.

Taking such resilient deformation of the rotors into consideration, there have been determined the gaps between the container inner wall surface and the locus faces of rotation of the rotor mountain portions. Accordingly, such gaps are naturally made great. Further, since the resilient deformation of the rotors causes the gaps between the screw meshing points to be increased, the material filled in the gaps are rotated as stuck to the rotors and is therefore not conductive to an extruding force. Thus, the performance of the extruder at the screw meshing portions is deteriorated. In this connection, there occurs a phenomenon that the increase in the pressure at the material extruding port is not proportional to the rotor drive force, but is weaken or saturated. This is more remarkable as the material viscosity is higher.

In the conventional twin conical screw extruder, each of the mountain portions of the screws of the rotors is made in the form of a trapezoid and the mountain portions of one screw are meshed, as fully

embedded in, with the valley portions of the other screw.

With the screw arrangement above-mentioned, when there is extruded a highly viscous material of which frictional resistance is high at the interface with the screws, or when the rotor drive force is increased in order to increase the pushing force at the tip extruding port, the resistance force for pushing the material back from the rotor tips is also increased. Accordingly, the increment of the pushing force at the tip extruding port with respect to the increment of the rotor drive force is suddenly decreased and then saturated.

Objects of the Invention

It is an object of the present invention to provide an extruder in which, even though the viscosity of a material to be extruded is high or the extruding amount of the material is increased to increase the internal pressure so that the rotor shafts are resiliently deformed, the rotor shafts do not interfere with the inner wall of the container, thus enabling to minimize the gaps between the rotor shafts and the container inner wall surface, so that the upper limit of the extruding force is increased.

Disclosure of the Invention

The twin conical screw extruder in accordance with the present invention comprises no-load pressurizing means arranged such that the rotor tips are pushed to and by each other at a predetermined force at a state where no load is applied to the conical rotors.

The term of "state where no load is applied" refers to the state where a material to be extruded is not present in the extruder container and the internal pressure applied by the material is zero.

According to the present invention, the no-load pressurizing means preferably comprises tip pressurizing members fitted to the tips of the shafts of the conical rotors in such a manner as to be adjusted in the positions thereof in the axial directions of the rotor shafts, and adjusting and setting devices of the tip pressurizing members.

According to the present invention, the no-load pressurizing means is preferably formed by means for adjusting the angle formed by the axes of bearings which support the twin rotors, the means being arranged such that, after the extruder is assembled such that no pushing force is applied to the twin rotors, the angle formed by the axes of the bearings is increased and adjusted such that a predetermined pushing force is applied to the twin rotors.

Preferably, conical annular portions are disposed at the rotor shafts, preferably at the tips thereof, as portions on which the pushing force by the rotors is centered.

Preferably, the conical annular portions are removably disposed at the tip ends of the rotors.

According to the present invention, each of the screws is formed such that each mountain portion is made substantially in the form of a trapezoid comprising: a tapering valley bottom face; a front wall face which stands from the round rear end portion of the tapering valley bottom face and which is substantially at a right angle to the tapering valley bottom face; a top face rearwardly extending from the top of the front wall face; and a rear inclined face which is gradually inclined downwardly from the rear edge of the top face toward the next rearward tapering valley bottom face. In the arrangement above-mentioned, the engagement relationship between the twin rotors on the plane including two axes thereof is such that the front edge of each valley bottom face of one rotor screw approaches most closely to the top of each front wall face of the other rotor screw.

Brief Description of the Drawings

Figure 1 is a plan view, with portions shown in section, of an extruder in accordance with an embodiment of the present invention;

Figure 2 is an enlarged section view of the tip portions of rotor shafts shown in Figure 1;

Figure 3 is a plan view, with portions shown in section, of an extruder in accordance with another embodiment of the present invention;

Figure 4 is a section view taken along the line A-A in Figure 3;

Figure 5 is a view for explaining the embodiment shown in Figure 3;

Figure 6 is a view for illustrating the operation of the extruder in accordance with the present invention;

Figure 7 is a section view of an example of a conical annular portion of the extruder in accordance with the present invention;

Figure 8 is a view of another example of the conical annular portion, illustrating the operation thereof;

Figure 9 is a plan view, with portions shown in section, of an example of the mountain portions of the screws in the extruder in accordance with the present invention;

Figure 10 is a section view taken along the line A-A in Figure 9; and

Figure 11 is an enlarged view in side elevation of the rotors along a plane P including the respective axes O₁ and O₂ of the rotors in Figure 10.

Detailed Description of the Preferred Embodiments

The following description will discuss an embodiment of the present invention with reference to Figs.

1 and 2.

Twin conical rotors 1A, 1B are to be rotated with screws thereof meshed with each other. The conical rotors 1A, 1B are supported at the base portions thereof by bearings 2A, 3A and 2B, 3B, respectively, and have free ends at the tips thereof. The conical rotors 1A, 1B are engaged at gears 4A, 4B with each other and driven as rotated in different directions. A container 5 comprises (i) an inner surface in the vicinity of a twin circular cone which constitutes the locus of rotation of the mountain portions of the screws of the conical rotors 1A, 1B, (ii) a material inlet port 6 disposed on the base portion of the twin circular cone and (iii) a material extruding port 7 at the tip of the container 5. The container 5 is secured to a base stand such that the material extruding port 7 is downwardly inclined.

As shown in Fig. 2, the rotor shafts 1A, 1B are respectively provided at the tips thereof with column portions 10A, 10B and tip pressurizing members 11A, 11B axially movably fitted to the column portions 10A, 10B, respectively. Each of the pressurizing members 11A, 11B has an outer surface which is generally in the form of a circular cone but more specifically in the form of a barrel with the center portion swelling out roundly with respect to both ends. Internal screw threads 12A, 12B are respectively formed at the tip surfaces of the conical rotors 1A, 1B along the axes thereof, and engaged with flanged bolts 13A, 13B. The pressurizing members 11A, 11B are respectively provided at the tips thereof with flange receiving portions 15A, 15B which are to receive flange portions 14A, 14B of the flanged bolts 13A, 13B, the flange receiving portions 15A, 15B being formed integrally with the pressurizing members 11A, 11B. The flanged bolts 13A, 13B respectively project from the tip surfaces of the pressurizing members 11A, 11B. The flanged bolts 13A, 13B are respectively provided in projecting portions thereof with through-holes 16A, 16B to be used for rotatably driving the bolts. Conical rotor caps 17A, 17B are respectively attached to the external threads at the tips of the bolts.

The following description will discuss how to assemble the members above-mentioned. The flanged bolts 13A, 13B and the pressurizing members 11A, 11B are temporarily secured at the base side, and the flanged bolts 13A, 13B are displaced to the tip side with drive rods passed through the through-holes 16A, 16B. Then, the rotor tips are turned to the outside, so that the rotor shafts are resiliently deformed and the pushing force by and between the rotor shafts is gradually increased. When the pushing force reaches a predetermined value, the rotor caps 17A, 17B are attached to complete the adjustment.

When the conical rotors 1A, 1B are rotatably driven, the rotors shafts come in contact with each other only at the contact point between the pressurizing members 11A, 11B, thus assuring gaps between the

mountain portions and the valley portions of the screws. As the internal pressure in the container is increased after a material to be extruded is supplied into the container, force apt to turn the rotor shaft tips to the outside is increased and the pushing force by and between the pressurizing members 11A, 11B is decreased. However, even at the time when the internal pressure reaches a maximum value, the pushing force by and between the pressurizing members 11A, 11B is slightly positive. This prevents the rotor shaft tips from being outwardly turned.

In Fig. 6, solid lines show a state where, with no load applied, the rotor tips are pushed to and by each other in the strongest manner so that the rotor shafts are flexed at maximum due to resilient deformation. Dotted lines in Fig. 6 show a state where the flexure of the rotor shafts is decreased due to an increase in internal pressure.

The following description will discuss another embodiment of the present invention with reference to Figs. 3, 4 and 7.

This embodiment differs from the embodiment shown in Figs. 1 and 2 in the following points.

The conical rotors 1A, 1B respectively have worm speed reduction mechanisms 18A, 18B in which follower pulleys 19A, 19B engaged with the worm shafts are driven by a motor 21 through a timing belt 20. A bearing box 22A housing bearings 2A, 3A and a bearing box 22B housing bearings 2B, 3B are independent from each other and are adapted to be angularly adjusted as rotated even at a very fine angle with respect to the container 5 of the extruder. In this connection, packings 25A, 25B excellent in resiliency are disposed between flanges which connect the container 5 and the respective bearing boxes 22A, 22B to each other. By fastening bolts 26A, 26B, the angle formed by the axes of the bearings is increased and a pushing force by and between the rotor shaft tips is increased. The bearing boxes 22A, 22B are so resiliently supported by the base member as to be rotated by a very fine angle with axes of the follower pulleys 19A, 19B serving as fulcrum points.

The rotor shafts 1A, 1B are respectively provided at the tips thereof with conical annular members 23A, 23B of which diameters are equal to or slightly greater than the effective diameters of the screws. The conical annular members 23A, 23B may be removably formed so that, when worn, the members 23A, 23B are replaced with new ones. In this connection, provision may be made such that only sleeve-like members 24 fitted to the outer peripheral portions of the annular members 23A, 23B are replaced.

In installation of the extruder having the arrangement above-mentioned, the extruder is assembled such that the shafts of the rotors 1A, 1B are straight with no pushing force applied at the tips of the rotors 1A, 1B. Then, the bolts 26A, 26B are fastened to rotate the bearing boxes 22A, 22B by a very fine angle

in the directions shown by arrows. At this time, the rotors 1A, 1B are flexed due to resilient deformation as shown by the solid lines in Fig. 6, thus producing a strong pushing force between the tips of the rotors 1A, 1B. In other words, the axes P_A , P_B of the twin circular cone of the container 5 are not identical with the axes of the bearings Q_A , Q_B and the angle α_1 formed by the two axes P_A and P_B is smaller than the angle α_2 formed by the axes Q_A and Q_B , as shown in Fig. 5.

The following description will discuss the function of the conical annular portions. As shown in Fig. 8, the mountain-portion diameter R_1 is greater than the valley-portion diameter R_2 on the plane where the screws are meshed with each other and the axes of both rotors are connected to each other. Accordingly, it is a matter of course that the peripheral speed at the mountain side is faster than the peripheral speed at the valley side. When metals respectively having different peripheral speeds come in contact with each other, there occurs a phenomenon of "scoring". When the two rotors have portions of which diameters R_0 are equal to each other, such portions present the same peripheral speed to prevent the occurrence of "scoring". The diameter R_0 is equal to or slightly greater than the effective diameter. When the conical annular portions have diameters slightly greater than the effective diameter, the pushing force is concentrated on the annular portions to assure gaps between the screws.

According to the present invention, the conical annular portions may be disposed not only at the rotor tips as shown in Fig. 7, but also at intermediate portions of the rotors as shown in Fig. 8.

Each of the outer peripheral surfaces of the conical annular portions or conical annular members may be made, for example, in the form of a barrel as shown in Fig. 2 (such surfaces are subjected to crowning). In this case, when such annular portions or members are adjusted in position in the axial directions of the rotor shafts, each effective diameter at the pushing point can be changed to adjust the pilot pressure and the contact between the annular portions or members is expanded from a point contact to a face contact due to resilient deformation of the rotor shafts. Accordingly, the pressure exerted to the contact portions is dispersed to improve the durability.

When the conical annular members (including the tip pressurizing members) are formed in a removable manner, only such members may be replaced with new ones to renew the extruder to the initial state at the time of assembling with the wear of the container or screws substantially eliminated.

According to the present invention, the means for adjusting the angle formed by the axes of the bearings may be arranged such that only one rotor is adjusted with the other rotor secured to the base stand together with the container. Alternately, when the power trans-

mission mechanism between both rotors is formed by bevel wheels, the base portions of the rotor shafts may be rotated with the mesh point of the bevel wheels serving as a fulcrum point. Further, when there are disposed bearing boxes which can be independently displaced as shown in Fig. 3, self-aligning rolling bearings may be used as the bearings and the rotors may be rotated around the rolling bearings.

The following description will discuss the shapes of the mountain portions of the screws in the twin conical extruder in accordance with the present invention.

Fig. 9 is a general plan view of the screws, while Fig. 10 is a section view taken along the line A-A in Fig. 9. Fig. 11 is an enlarged view in side elevation of the screws along the plane P in Fig. 10 with hatching omitted.

Each of the mountain portions of the screws is made substantially in the form of a trapezoid comprising: a tapering valley bottom face 31 located in the same plane as the plane defined by the rotation locus of a valley portion; a front wall face 33 which stands from the round rear end portion 32 of the tapering valley bottom face 31 and which is substantially at a right angle to the tapering valley bottom face 31; a top face 35 rearwardly extending from the top 34 of the front wall face 33; and a rear inclined face 37 which is gradually linearly inclined downwardly from the rear edge 36 of the top face 35 toward a tapering valley bottom face 31a which is rearwardly located by one pitch with respect to the tapering valley bottom face 31. The engagement relationship between the rotors 1A, 1B on the plane P including two axes O₁, O₂ shown in Fig. 10 is such that, as shown in Fig. 11, the front edge 38 of each valley bottom face of the screw of one rotor 1A approaches most closely to the top of each front wall face 33b of the screw of the other rotor 1B.

In this embodiment, the screw pitch is equal to 50mm, the axial length of the top face 35 is equal to 10 mm, and the axial length of the rear inclined face 37 is equal to 15 mm.

According to the present invention, the front wall faces of the screws are adapted to push out a material strongly and the rear inclined faces thereof are adapted to separate the material from the rotors to decrease the frictional resistance at the interfaces between the rotors and the material, thereby to increase the material extruding force. Further, as shown in Fig. 11, when the rotors are meshed with each other, there are still formed suitable spaces S₁, S₂ in which the material remains. This prevents the internal pressure from being excessively increased to turn the rotor shafts outwardly, even at the rotor tip portions where the internal pressure is increased. This reduces the risk that the rotor free ends interfere with the inner wall surface of the container.

Claims

1. A twin conical screw extruder comprising:
two conical rotors (1A,1B) having free ends at the tips thereof and supported at the base ends thereof by bearings (2A,3A,2B,3B) the rotors being screw threaded, the rotors being rotatably driveable in opposite angular directions with the threads meshed with each other;
- 5 a twin conical housing (5) having: an inner wall surface in the vicinity of the two circular cones which constitute the loci of rotation of the tops of the threads of the two conical rotors: an inlet port (6) toward the base thereof; and an extrusion port (7) at the tip thereof; and
no-load pressurizing (11A,11B) (23A,23B)
means arranged such that, at a no-load state in which the container is not filled with a material to be extruded, the tips of the rotors are pushed to and by each other with a predetermined force, causing the rotors to be resiliently deformed so that the shafts of the rotors are forcibly flexed.
- 10 2. A twin conical screw extruder according to claim 1, in which the no-load pressurizing means comprises tip pressurizing members (11A,11B) disposed at the tips of the rotor shafts (1A,1B) and an adjusting and setting device (13A,13B) for adjusting the positions of the tip pressurizing members in the axial directions of the rotor shafts and for securing the tip pressurizing members in position.
- 15 3. A twin conical screw extruder according to claim 1 or 2, in which the no-load pressurizing means comprises pressurizing members (23A,23B) disposed at or in the vicinity of the tips of the rotor shafts (1A,1B) and means (26A,26B) for adjusting the angle formed by the axes of bearings (2A,3A,2B,3B) which support the twin rotors.
- 20 4. A twin conical screw extruder according to any preceding claim, in which the conical rotors (1A,1B) are each provided at corresponding positions with a conical annular member the diameter of which is substantially equal to the effective diameter of the screw, the conical annular members being adapted to receive a pushing force by and between the rotors.
- 25 5. A twin conical screw extruder according to claim 4, in which each of the conical annular members is in the form of a barrel in which the centre portion swells out roundly with respect to both ends.
- 30 6. A twin conical screw extruder comprising:
two conical rotors (1A,1B) having free ends at the tips thereof and supported at the base

ends thereof by bearings (2A,3A,2B,3B) the rotors being screw threaded, the rotors being rotatably driveable different angular directions with the threads meshed with each other; and

a twin conical housing (5): an inner wall surface in the vicinity of two circular cones which constitute the loci of rotation of the tops of the threads of the two conical rotors; an inlet port (6) toward the base portion thereof; and an extrusion port (7) at the tip thereof;

the cross-section of the threads being substantially trapezoid, the thread comprising:

a front wall face (33) which stands from the round rear end portion (32) of the tapering bottom face (31) of the valley between two adjacent turns of the thread, and the front wall face being substantially at a right angle to the tapering valley bottom face; a top face (35) rearwardly extending from the top (34) of the front wall face; and a rear inclined face (37) which is gradually linearly inclined downwardly from the rear edge (36) of the top face toward the next rearward tapering valley bottom face,

the engagement relationship between the twin rotors on the plane including the two axes of the rotors being such that the front edge (38) of each valley bottom face (31) of one rotor screw approaches most closely to the top of each front wall face (33) of the other rotor screw.

7. A twin conical screw extruder according to claim 6, in which the longitudinal length of each top face (35) is from 15 to 30% of the axial pitch of the threads.

8. A twin conical screw extruder according to any of claims 1 to 5 in combination with either claims 6 or 7.

9. A twin conical screw extruder comprising:

two conical rotors (1A,1B) having free ends at the tips thereof and supported at the base ends thereof by bearings (2A,3A,2B,3B), said rotors being provided on the lateral sides thereof with screws, said rotors being adapted to be driven as rotated in different directions with said screws meshed with each other;

a twin conical container (5) having (i) an inner wall surface in the vicinity of two circular cones which constitute the loci of rotation of the tops of the mountain portions of said screws of said two conical rotors, (ii) a material inlet port (6) on the base portion thereof and (iii) a material extruding port (7) at the tip thereof; and

no-load pressurizing (11A,11B) (23A,23B) means arranged such that, at a no-load state where said container is not filled with a material to be extruded, the tips of said rotators are

pushed to and by each other at a predetermined force, causing said rotors to be resiliently deformed so that the shafts of said rotors are forcibly flexed.

5 10 15 20 25 30 35 40 45 50 55

10. A twin conical screw extruder comprising:
two conical rotors (1A,1B) having free ends at the tips thereof and supported at the base ends thereof by bearings (2A,3A,2B,3B), said rotors being provided on the lateral sides thereof with screws, said rotors being adapted to be driven as rotated in different directions with said screws meshed with each other; and

a twin conical container (5) having (i) an inner wall surface in the vicinity of two circular cones which constitute the loci of rotation of the tops of the mountain portions of said screws of said two conical rotors, (ii) a material inlet port (6) on the base portion thereof and (iii) a material extruding port (7) at the tip thereof;

said screws being formed such that each of the mountain portions of said screws is made substantially in the form of a trapezoid comprising: a tapering valley bottom face (31); a front wall face (33) which stands from the round rear end portion (32) of said tapering valley bottom face and which is substantially at a right angle to said tapering valley bottom face; a top face (35) rearwardly extending from the top (34) of said front wall face; and a rear inclined (37) face which is gradually linearly inclined downwardly from the rear edge (36) of said top face toward the next rearward tapering valley bottom face,
the engagement relationship between said twin rotors on the plane including two axes of said rotors being such that the front edge (38) of each valley bottom face (31) of one rotor screw approaches most closely to the top of each front wall face (33) of the other rotor screw.

40

45

50

55

Fig. 1

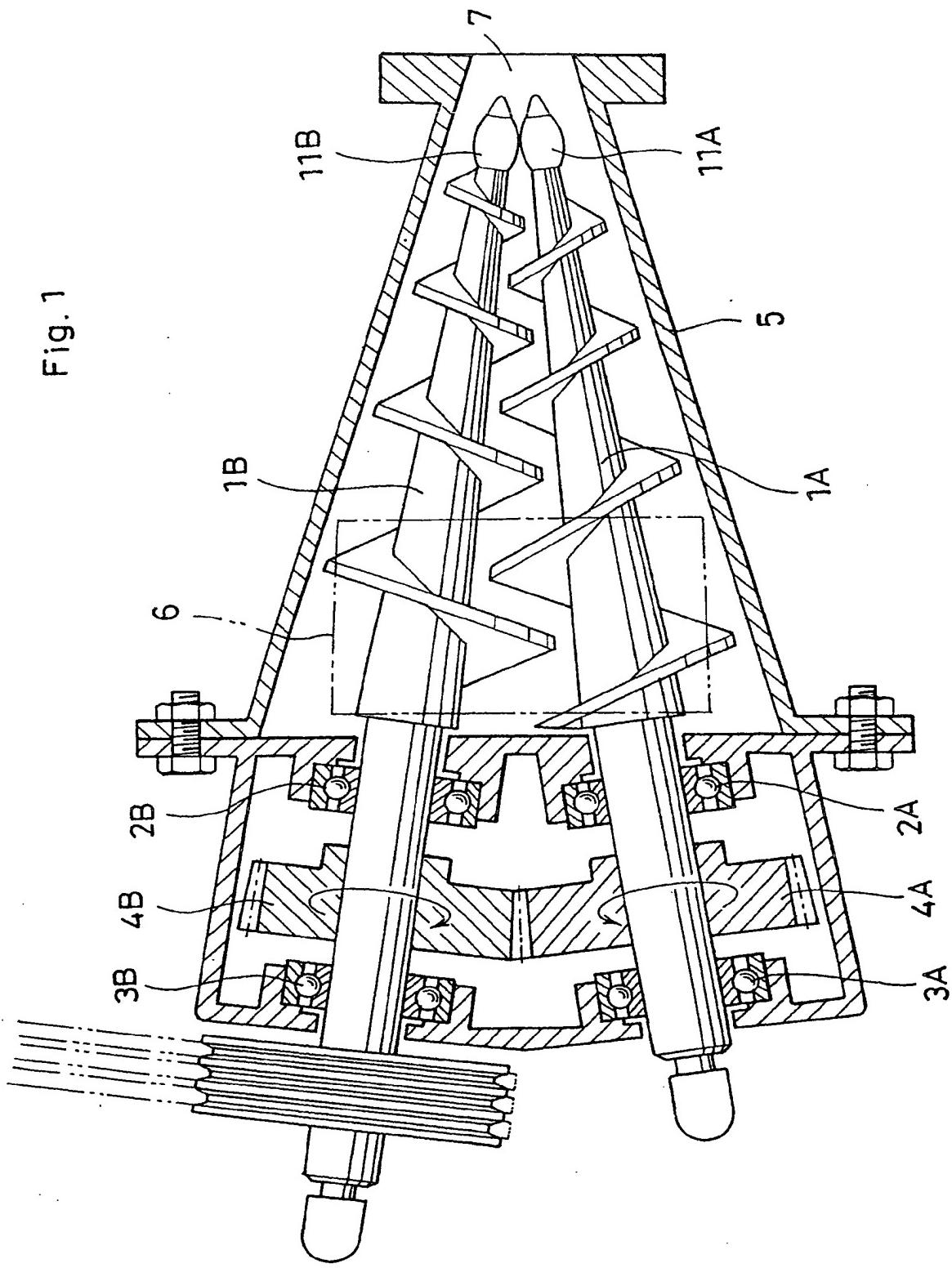
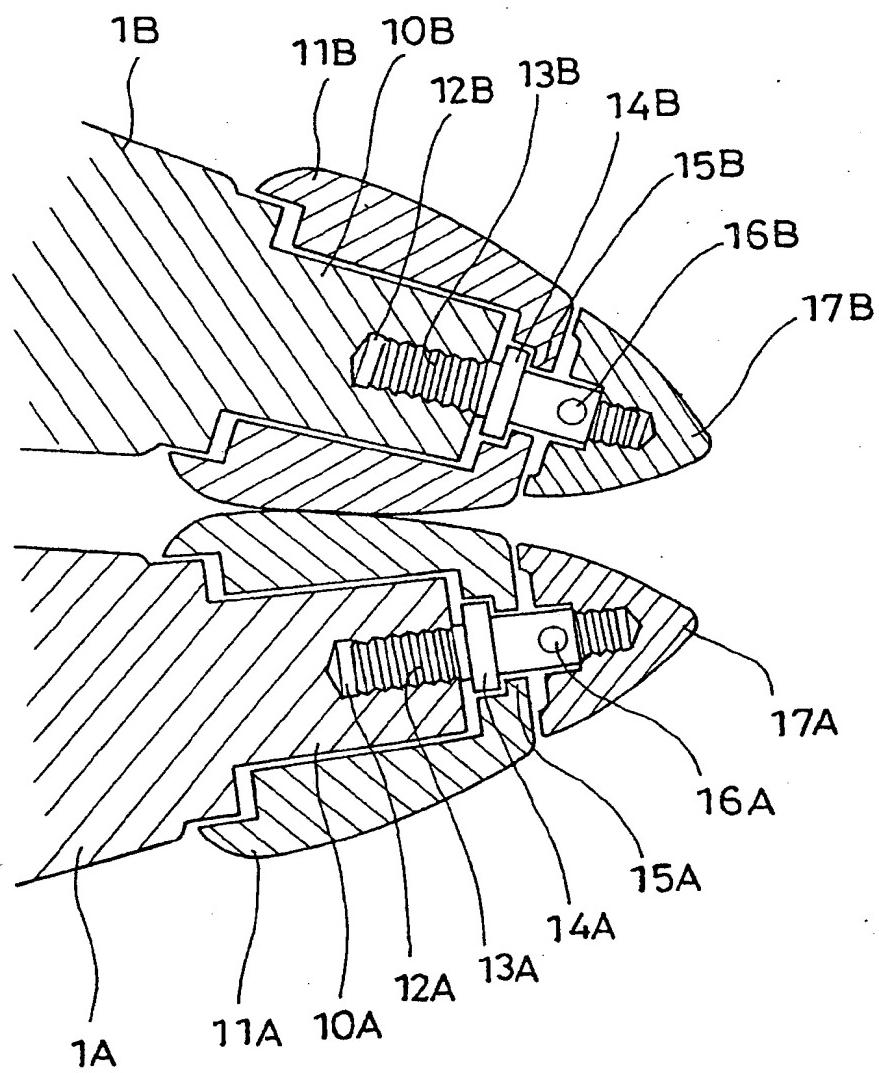


Fig. 2



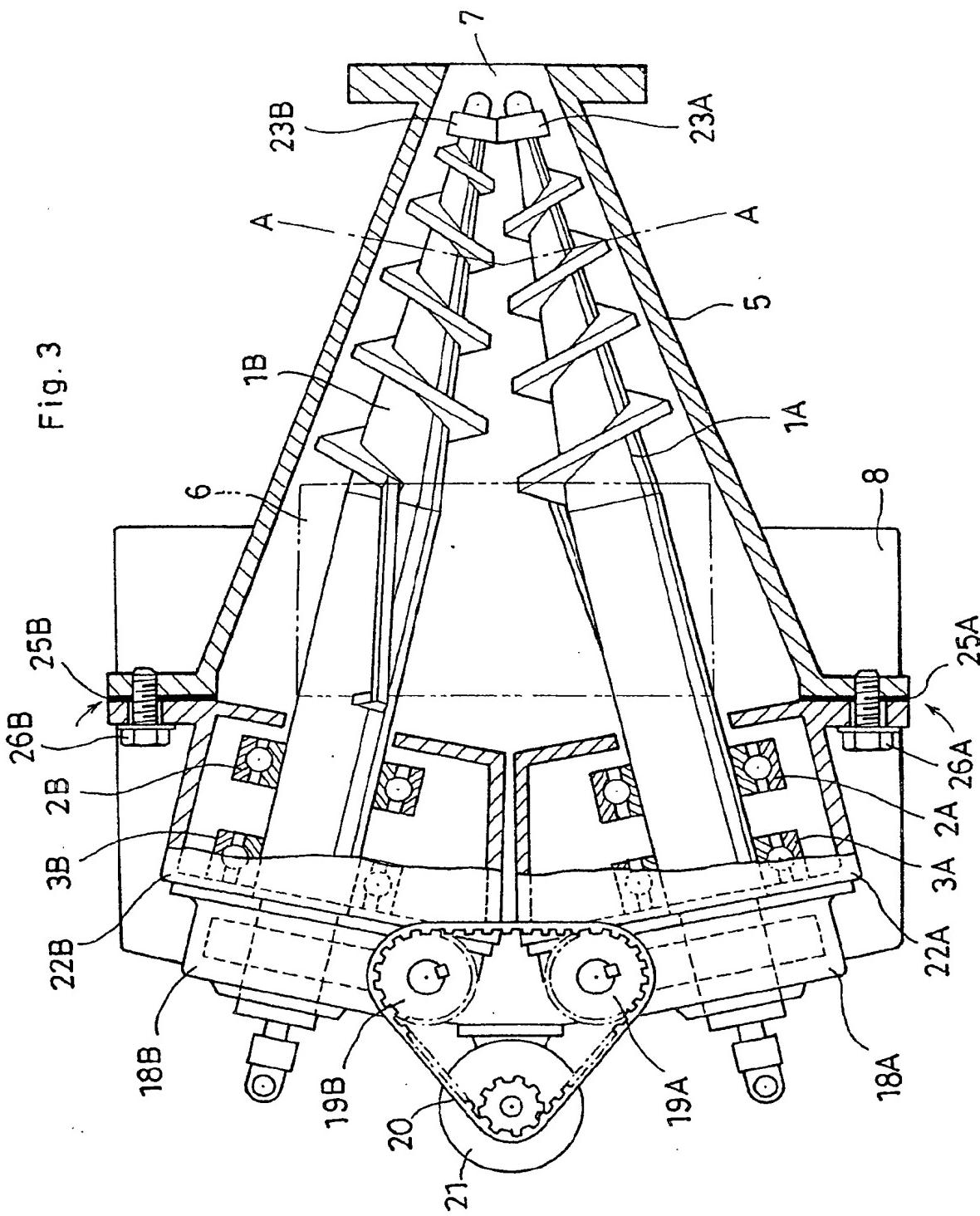


Fig. 4

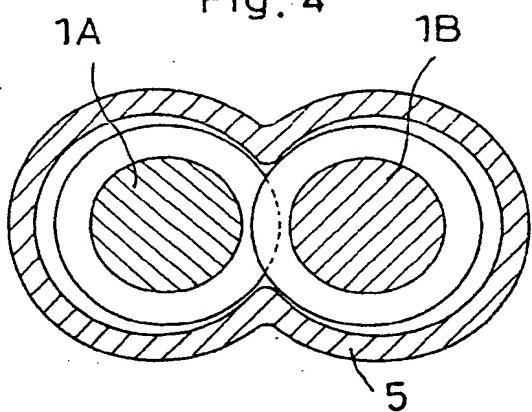


Fig. 5

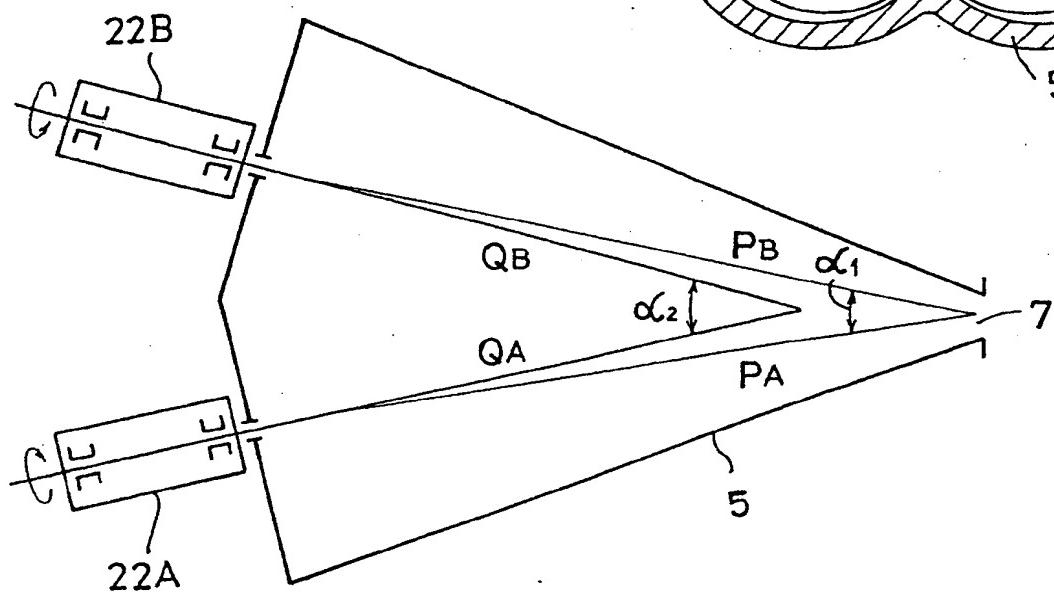


Fig. 6

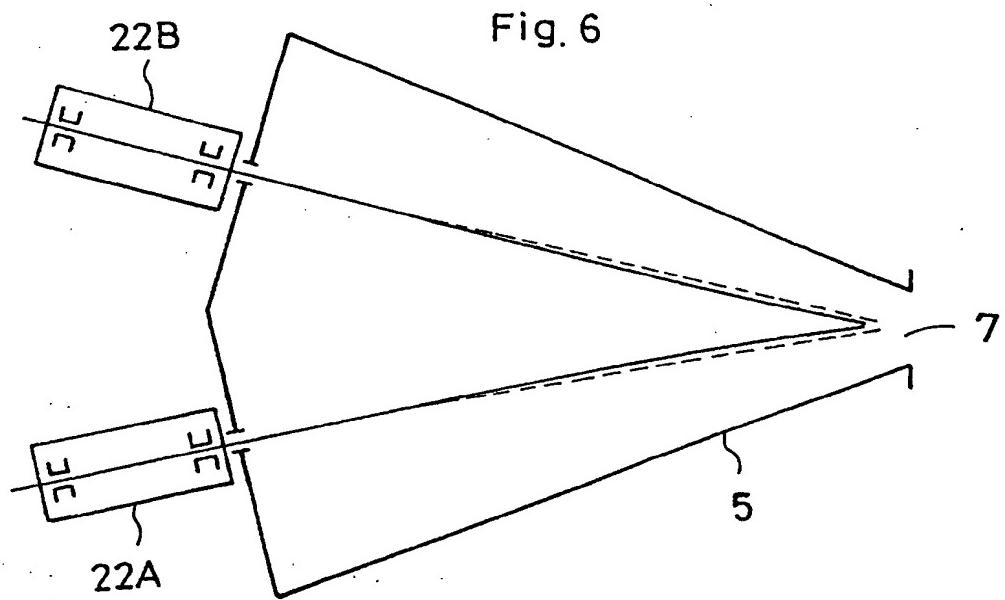


Fig. 7

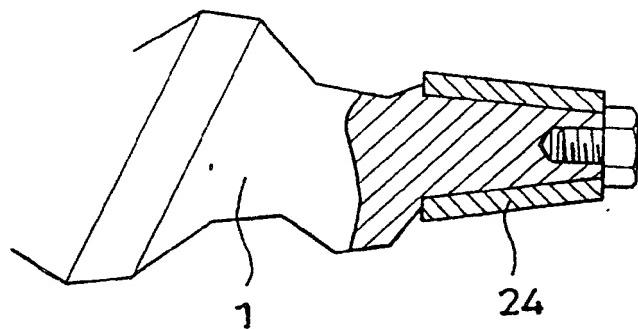


Fig. 8

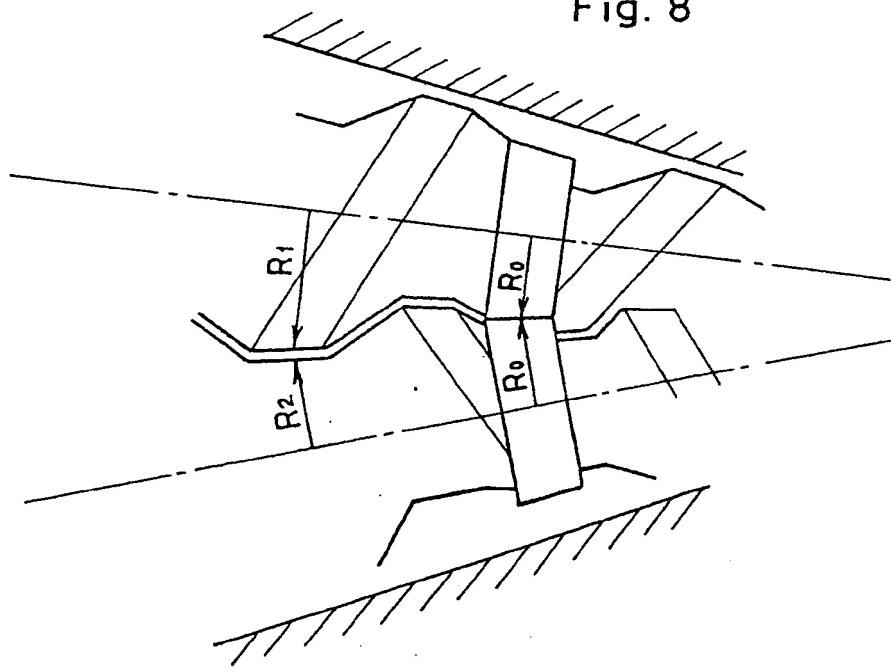


Fig. 9

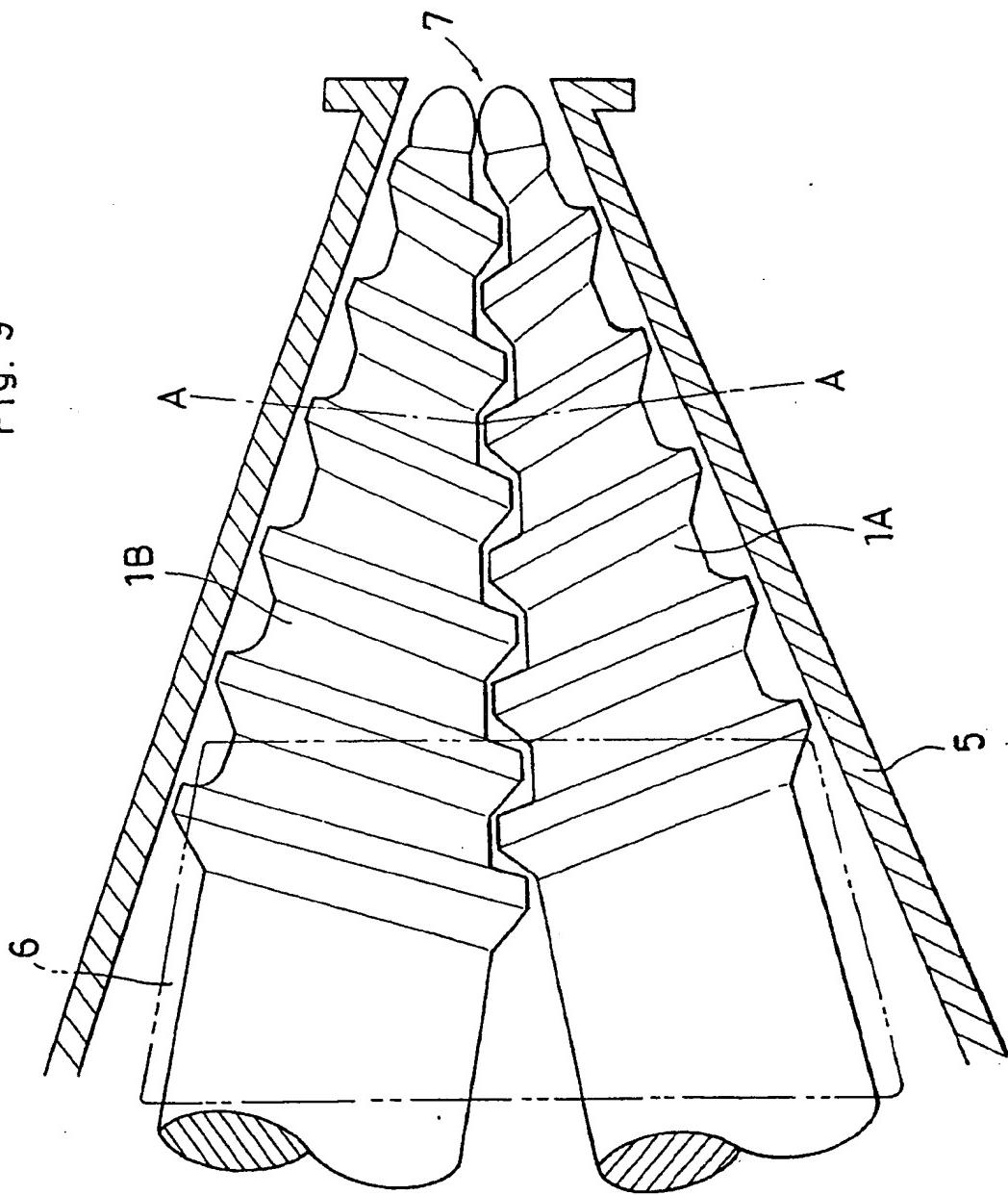


Fig. 10

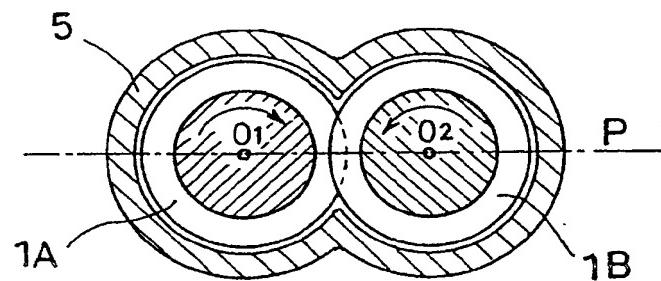
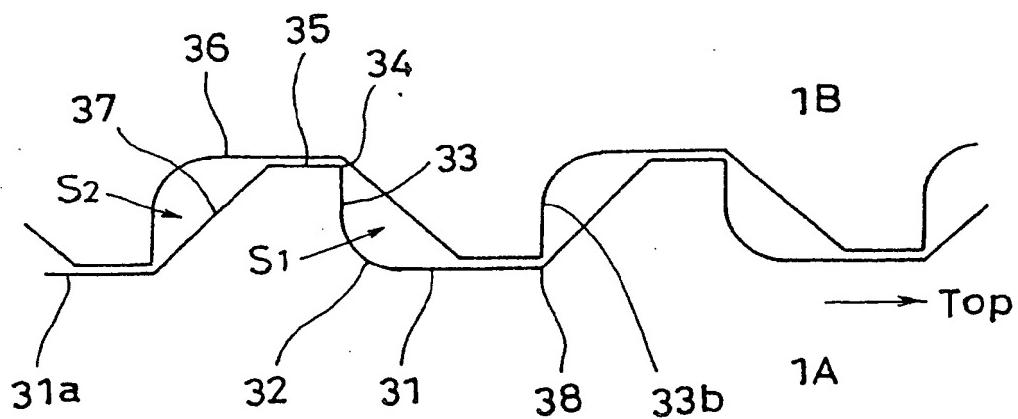


Fig. 11





(19) Europäisches Patentamt
European Patent Office
Office européen des brevets



(11) Publication number : **0 472 431 A3**

(12)

EUROPEAN PATENT APPLICATION

(21) Application number : **91307743.4**

(51) Int. Cl.⁵ : **B29C 47/40**

(22) Date of filing : **22.08.91**

(30) Priority : **22.08.90 JP 222260/90**
22.08.90 JP 222261/90

(43) Date of publication of application :
26.02.92 Bulletin 92/09

(84) Designated Contracting States :
DE FR GB SE

(88) Date of deferred publication of search report :
24.02.93 Bulletin 93/08

(71) Applicant : **Moriyama, Masao**
13-508, Tendocho 17
Nishinomiya, Hyogo 663 (JP)

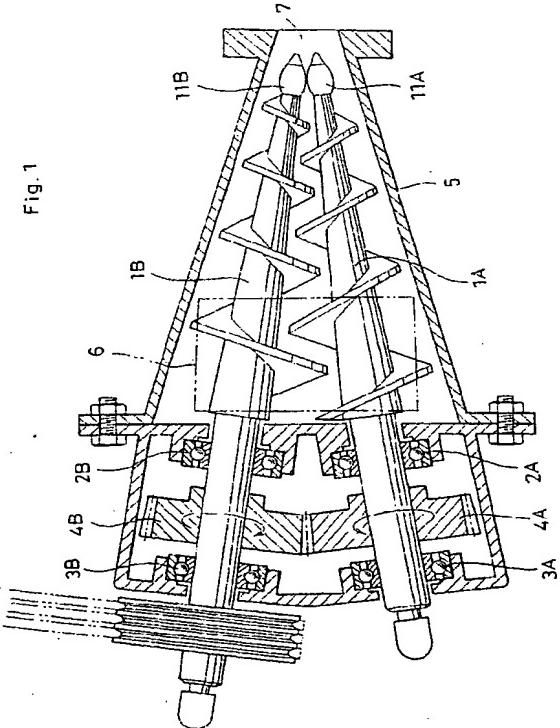
(72) Inventor : **Moriyama, Masao**
13-508, Tendocho 17
Nishinomiya, Hyogo 663 (JP)

(74) Representative : **Marlow, Nicholas Simon**
Reddie & Grose 16, Theobalds Road
London WC1X 8PL (GB)

(54) **Twin conical screw extruder.**

(57) A twin conical screw extruder comprises two conically threaded rotors 1A,1B in a conical housing 5. The axes of the rotors converge toward their tips, adjacent the outlet 7 of the housing. The tips are each provided with a resilient pressurizing member 11A,11B. These bear on each other to urge the rotors apart, thereby enabling them to resist the force directing them further apart exerted by material being extruded.

Fig. 1



EP 0 472 431 A3

Jouve, 18, rue Saint-Denis, 75001 PARIS



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 91 30 7743
Page 1

BEST AVAILABLE COPY

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl.s)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
A	DERWENT JAPANESE PATENTS REPORT Section Ch, Week 38, 3 November 1982 Derwent Publications Ltd., London, GB; Class A, AN 80709 & SU-882 765 (IND RUBBER RES INST) 23 November 1981 * abstract * ---	1-5, 9	B29C47/40
A	US-A-3 804 382 (W.W. PULTZ) 16 April 1974 * column 2, line 1 - line 12 * * column 3, line 51 - column 4, line 1; figure 2 *	1-5, 9	
A	PATENT ABSTRACTS OF JAPAN vol. 4, no. 94 (M-19)(576) 8 July 1980 & JP-A-55 051 543 (TOSHIBA KIKAI K.K.) 15 April 1980 * abstract * ---	1	
A	WO-A-9 007 417 (B. BRENDL ET AL.) * page 8, line 37 - page 9, line 28; figures 4, 5 *	1, 9	TECHNICAL FIELDS SEARCHED (Int. Cl.s)
A	EP-A-0 275 485 (DR. J. WEBER) * column 2, line 14 - line 28; figure *	1	B29C B29B B01F
A	FR-A-2 471 723 (FA. CINCINNATI MILACRON AUSTRIA AG) * page 2, line 14 - line 24 * * page 2, line 27 - page 3, line 4; figure 1 * * page 3, line 12 - line 22; figure 5 *	1	
A	FR-A-535 892 (A. OLIER) * figure 1 *	6-8, 10	
		-/-	
The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	10 DECEMBER 1992	TOPALIDIS A.	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone	T : theory or principle underlying the invention		
Y : particularly relevant if combined with another document of the same category	E : earlier patent document, but published on, or after the filing date		
A : technological background	D : document cited in the application		
O : non-written disclosure	L : document cited for other reasons		
P : intermediate document	& : member of the same patent family, corresponding document		



European Patent
Office

EP 91307743

CLAIMS INCURRING FEES

The present European patent application comprised at the time of filing more than ten claims.

- All claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for all claims.
- Only part of the claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims and for those claims for which claims fees have been paid,
namely claims:
- No claims fees have been paid within the prescribed time limit. The present European search report has been drawn up for the first ten claims.

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions.
namely:

see sheet B

BEST AVAILABLE COPY



All further search fees have been paid within the fixed time limit. The present European search report has been drawn up for all claims.



Only part of the further search fees have been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the inventions in respect of which search fees have been paid.

namely claims:



None of the further search fees has been paid within the fixed time limit. The present European search report has been drawn up for those parts of the European patent application which relate to the invention first mentioned in the claims.

namely claims:



European Patent
Office

EUROPEAN SEARCH REPORT

Application Number

EP 91 30 7743
Page 2

DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl.5)						
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim							
A	FR-A-1 008 308 (M.G. WAMPACH) * page 2, right column, line 12 - line 17; figures 3,4 *	6-8,10 -----							
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)						
<p>The present search report has been drawn up for all claims</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Place of search</td> <td style="width: 33%;">Date of completion of the search</td> <td style="width: 34%;">Examiner</td> </tr> <tr> <td>THE HAGUE</td> <td>10 DECEMBER 1992</td> <td>TOPALIDIS A.</td> </tr> </table>				Place of search	Date of completion of the search	Examiner	THE HAGUE	10 DECEMBER 1992	TOPALIDIS A.
Place of search	Date of completion of the search	Examiner							
THE HAGUE	10 DECEMBER 1992	TOPALIDIS A.							
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document							
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document									



European Patent
Office

EP 91 30 7743 -B-

LACK OF UNITY OF INVENTION

The Search Division considers that the present European patent application does not comply with the requirement of unity of invention and relates to several inventions or groups of inventions, namely:

1. Claims 1-5,9: Apparatus for applying prestress to the two conical rotors of an extruder
2. Claims 6-8,10: Shape of screw threads in a twin conical extruder

BEST AVAILABLE COPY

THIS PAGE BLANK (USPTO)